

with this fixture, the attached cables *E* and *F* passing over pulleys above. These weights not only counterbalance the overhanging parts of the heavy fixture, but also make it easier to elevate the knee for feeding the cutter down past the work.

Radial Fixture having Hand- and Power-operated Feed. — The yoke of the sight mechanism is a cast-steel member which carries the telescopes at its forward end and is attached at the

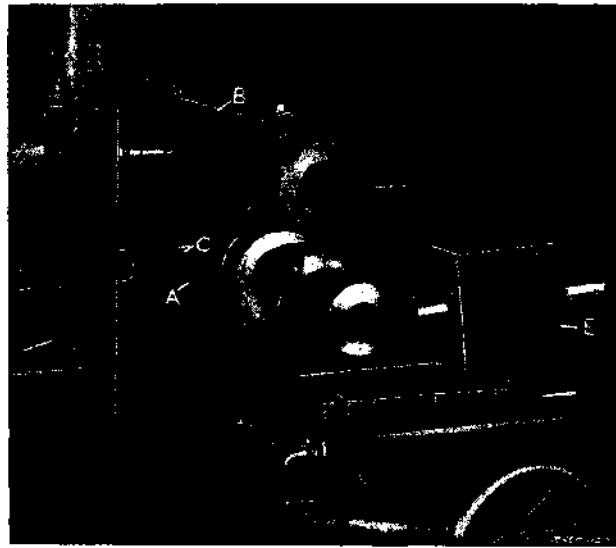


Fig. 21. Fixture for Milling Curved Openings in Bronze Recoil Liners

rear to the sight-bar. There are some radial milling operations on the rear end of the yoke. The curved surfaces at the end of the yoke are milled to the required radius by a type of fixture which, in many respects, is similar to the radial designs already referred to in connection with the sight-bar. The base of the fixture (see Fig. 20) is bolted to the table of a column-and-knee type of milling machine, and the upper part *B* is free to swing about a pivot located at the required radial distance. One radial milling operation is that of form-milling the worm-gear segment in which worm teeth are cut later to mesh with a worm which enables the yoke to be adjusted horizontally. Several